

DaimlerChrysler AG

Patent claims

- 5 1. A method for joining at least one joint part (3),  
provided with a through-opening (4), to a hollow profile  
(1),
  - in which the joint part (3) is pushed with its through-opening (4) onto the hollow profile (1) up to a joint point (2),
  - in which the hollow profile (1) is expanded at least at the joint point (2),  
characterized
    - in that an adhesive (11) is arranged between an inner side (6) of the joint part (3) and an outer side (5) of the hollow profile (1) before the expansion in such a way that
    - the adhesive (11) adheres to the inner side (6) and to the outer side (5) in the region of the joint point (2)  
after the expansion.
- 15 2. The method as claimed in claim 1, characterized in that the adhesive (11) is arranged in such a way that it fully encloses the hollow profile (1) in an annular manner in the circumferential direction.
- 25 3. The method as claimed in claim 1 or 2, characterized in that the adhesive (11) is arranged in a recess (12) which is formed on the inner side (6) or on the outer side (5) before the expansion and which is essentially leveled after the expansion.
- 30 4. The method as claimed in one of claims 1 to 3, characterized in that the adhesive (11) is arranged in

the form of a solid on the inner side (6) or on the outer side (5) before the joint part (3) is pushed onto the hollow profile (1).

5 5. The method as claimed in one of claims 1 to 4, characterized

- in that the hollow profile (1) is also expanded directly adjacent to the joint part (3) in such a way that
- 10 - the hollow profile (1) has, after the expansion, at least on one side of the joint part (3), a step (13) bearing laterally against the joint part (3).

15 6. The method as claimed in one of claims 1 to 5, characterized in that the hollow profile (1) is expanded by means of internal high pressure at least at the joint point (2).

20 7. A hollow profile having a joint part (3) joined thereto,

- the joint part (3) being pushed with its through-opening (4) onto the hollow profile (1) up to a joint point (2),
- the hollow profile (1) being expanded at least at the 25 joint point (2),

characterized in that an adhesive (11) is arranged between an inner side (6) of the joint part (3) and an outer side (5) of the hollow profile (1), this adhesive (11) adhering to the inner side (6) and to the outer side 30 (5).

8. The hollow profile as claimed in claim 7, characterized in that the hollow profile (1) is expanded directly adjacent to the joint part (3) in such a way

- 13 -

that it bears laterally against the joint part (3) by means of a step (13).

9. The hollow profile as claimed in claim 7 or 8,  
5 characterized in that the joint part (3) has a fastening section (7) with which a combination (8) of joint part (3) and hollow profile (1) can be fastened to another component.